

Work Order ID 142086

Wednesday, February 24, 2016 11:26:15 AM

142086

U/R

Page 1

Item ID: D412-664-403 Accept *N900040100* Setup Start *NS1*
Revision ID: URF 15-561 Stop *NS2*
Item Name: 412 Stainless Steel Aft Crosstubes - High
Start Date: 3/21/2016 Start Qty: 1.00 *1* Cust Item ID:
2/24/2016 Required Date: 3/11/2016 Req'd Qty: 1.00 *1* Customer:
Reference: 4/08/2016

Approvals: Process Plan: MLS Date: FEB 24 2016 Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D412-664-443	A U/R <u>OK</u> <u>10/13/13</u>							DAS 21 9-89	1611-02
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPPD412-664-403		CHG001						
								DAS 27 9-89	
									NOV 07 2016
110	BENDING MACHINE - CROSSTUBES	0.00							
110									
CNC Bend 2	Memo	0.03							
CNC Alpha 160 Bender	Bend tube as per Dwg D412-664-443 using CNC bender program _____ and Folio FT _____								
	****USE (4) DT9824 SHIM BLOC TO CHECK STRAIGHTNESS****								
127	QC15- Crosstube Dimensional Check	0.00							
127									
QC	Memo	0.00							
Quality Control	***MARK CUT LINES***								

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
128		0.00							
128									
Crosstubes	Memo	0.01							
Crosstubes	CUT TUBE AT HEIGHT ON FAI SHEET								
	VERF HEIGHT <u>34.62</u> BY QC 15 LEVEL INSPECTOR <u>mm L</u>								
	VERF TWIST <u>115</u> BY QC15 LEVEL INSPECTOR <u>mm L</u>								
130		0.00							
130									
Crosstubes	Crosstubes								
Crosstubes	Memo	0.03							
	1- Drill Tube as per Dwg D412-664-443 Using DT <u>8550</u> Drill Jigs, Set-up drill table as per QSI 010								
	2-Deburr								
	3- Engrave Part # and Batch # as per Dwg D412-664-443								
	4-Remove all marks from tube within limits of D412-664-43 DWG. <u>BC</u>								

16/04/04

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* QC Quality Control	QC6- Inspect dimensions to drawing Memo	0.00 0.00				1			DAS 38 9-89 APR 04 2016
174 *174* Outsource2 Outsource process - NDT	Outsource process - NDT per QSI038 4.1 Memo ISSUE P/O TO ACCUREN: 31971	0.00 3.00				1		APR 11 2016	DAS 13 9-89
176 *176* Packaging Packaging	Receive & Inspect for Damage & Mat'l Certs Memo	0.00 0.00				1		5016-04-12	

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Required Date: 3/11/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
178 *178* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				1			DAS 38 9-89 APR 28 2016
180 *180* SprayPaint Spray Painting	SprayPaint Memo ***USE AXALTA 230S PRE-TREATMENT AS PER QSI005*** AXALTA BATCH: <u>132474</u> 1-Prime inside & outside crosstube as per QSI 005 4.2 BATCH: <u>134454</u> 2- MASK UNDERSIDE OF CROSSTUBE AS SHOWN ON DWG BEFORE PAINTING 3 -Paint Outside of Tube as per Dart QSI 005 4.2 BATCH: <u>134341</u> 4- After painting remove masking and apply matte clear coat per QSI005 4.2 CLEAR BATCH: <u>133641</u>	0.00 0.01				1			DAS 41 9-89 16-4-21

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Item ID: D412-664-403 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: URF 15-561 Stop ***NS2***
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Required Date: 3/11/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	Crosstubes	0.00							
200									
Crosstubes									
Crosstubes									
	Memo	0.01							
	1- Install center support using scoth-weld DP460 per QSI 015, as per DWG. note 12. Install supports clamps using as per Dwg D412-644-443. Install clamp with rubber cushion as per DWG. note 13. ***ENSURE CLAMPS ARE ON TOP OF CROSSTUBE SUPPORT*** Torque clamps on support to 80-100 IN-LBS AS PER DWG.								
	A/R scoth-weld DP460 BATCH #: <u>134469</u> EXP DATE: <u>4/17</u>								
	2- **IF NOT ALREADY PRESENT ON CHAFFING SHEILD.** Apply a thin coat of proseal 890 per QSI 015 on inside concave surface of chafing shield and let cure per manufacturer's instructions. Install prosealed chafing shield onto crosstube by applying a thin coat of proseal 890 onto crosstube. Be sure to eliminate any air gaps. Install and torque clamps on chafing shield to 40-50 IN-LBS AS PER DWG.								
	A/R Proseal 890 Batch: <u>135390</u> EXP DATE: <u>12/16</u>								
	AFTER FINISH CURE TIME 24H START CURE TIME: <u>16-10-19</u> FINISH CURE TIME: <u>16-10-20</u>								
	PRIOR TO PACKAGING RE-CHECK TORQUE ON CLAMPS AFTER CURED FOR 24H.								

DAS
41
9-89
16-10-19

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Item ID: D412-664-403 Accept ***N900040100*** Setup Start ***NS1***
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Start Date: 2/24/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 3/11/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210 *210* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo PRIOR TO PACKAGING RE-CHECK TORQUE ON CLAMPS AFTER CURED FOR 24H.	0.00 0.00				(			DAS NOV 03 2016
220 *220* Packaging Packaging	Pick Kit Memo	0.00 0.00							DAS APR 30 2016
230 *230* QC Quality Control	QC4- 100% Inspect kits for completeness Memo	0.00 0.00							DAS NOV 07 2016

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Item ID: D412-664-403 **Accept** ***N900040100*** **Setup Start** ***NS1***
Revision ID: URF 15-561 **Stop** ***NS2***
Item Name: 412 Stainless Steel Aft Crosstubes - High
Start Date: 2/24/2016 **Start Qty:** 1.00 ***1*** **Cust Item ID:**
Required Date: 3/11/2016 **Req'd Qty:** 1.00 ***1*** **Customer:**
Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** ***NR1***
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240	Packaging	0.00							
240									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD412-664-443								
	Location: _____								
	PPP Rev: _____ Sold								
250	QC21- Final Inspection - Work Order Release	0.00							
250									
QC	Memo	0.00							
Quality Control									

DAS 27 9-89 **DAS 28 9-89** **NOV 07 2016**

DAS 21 9-89 **NOV 07 2016**

DAS 21 9-89 **NOV 07 2016**

Picklist Print

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Work Order ID: 142086

142086

Parent Item: D412-664-403

D412-664-403

Parent Item Name: 412 Stainless Steel Aft Crosstubes - High

Start Date: 2/24/2016

Required Date: 3/11/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 13.10.25 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D412-664-443TRN		Manufactured	No			110	Each	4.0000	1	1			
D412-664-443TRN									**	1 1		BC 16/03/28	
Crosstube Turning Detail													

Location	Loc Qty	Loc Code
LG003	4	
139897	1	
139898	1	
139899	1	
139900	1	

D3595-063-530

Manufactured No

200

Each

38.0000

2

2

DAS
41
9-89

16-10-19

D3595-063-530

Rubber Cushion 0.63" wide x 5.30" Long

Location	Loc Qty	Loc Code
FG	1	
82656	1	
LG051	1	
132515	1	
LG052	36	
138921	36	

D4909-1

Manufactured No

200

Each

9.0000

1

1

DAS
41
9-89

16-10-19

D4909-1

Support

Location	Loc Qty	Loc Code
LG053	9	
135507	5	
140154	4	

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Parent Item: D412-664-403

D412-664-403

Parent Item Name: 412 Stainless Steel Aft Crosstubes - High

Start Date: 2/24/2016

Required Date: 3/11/2016

Start Qty: 1.00

Required Qty: 1.00

D4910-1 Manufactured No

200 Each 17.0000 2 2

D4910-1

Chaffing Shield

DAS
41
9-89

16-10-19

Location

Loc Qty

Loc Code

LG053

17

139520

8

141315

9

2

MS21920-26

Purchased No

200 Each 27.0000 4 4

MS21920-26

Clamp

DAS
41
9-89

16-10-19

Location

Loc Qty

Loc Code

LG057

27

M132045

1

M133234

2

M133483

4

M133577

20

4

MS21920-28

Purchased No

200 Each 92.0000 2 2

MS21920-28

Clamp

DAS
41
9-89

16-10-19

Location

Loc Qty

Loc Code

FG

1

105884

1

LG051

1

M132169

1

LG057

90

M130400

50

M133090

2

M134130

38

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Work Order ID: 142086

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Parent Item: D412-664-403

D412-664-403

Parent Item Name: 412 Stainless Steel Aft Crosstubes - High

Start Date: 2/24/2016

Required Date: 3/11/2016

Start Qty: 1.00

Required Qty: 1.00

AN6-40A

Purchased

No

220

Each

66.0000

4

4

AN6-40A

3/8-24 BOLT X 3" LONG

**

134509

DAS
6
9-89

DAS
28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

over005

24

M133316

24

ST333

42

M133769

42

AN6-41A

Purchased

No

220

Each

35.0000

2

2

AN6-41A

Bolt

**

DAS
6
9-89

DAS
28
9-89

DAS
28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

over005

25

M133577

25

ST286A

1

M129913

1

ST333

9

M131957

9

AN960JD616

NAS1149D0663J

Purchased

No

220

Each

0.0000

18

18

AN960JD616

Washer

**

134360

DAS
6
9-89

DAS
28
9-89

DAS
28
9-89

DAS
27
9-89

APR 30 1989

Picklist Print

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Work Order ID: 142086

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Parent Item: D412-664-403

D412-664-403

Parent Item Name: 412 Stainless Steel Aft Crosstubes - High

Start Date: 2/24/2016

Required Date: 3/11/2016

Start Qty: 1.00

Required Qty: 1.00

MS21042L6

Purchased

No

220

Each

208.0000

6

6

MS21042L6

Nut

DAS
28
9-89

APR 30 2016

DAS
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST007

100

m134055

100

ST303

108

m133134

5

m133932

3

m133938

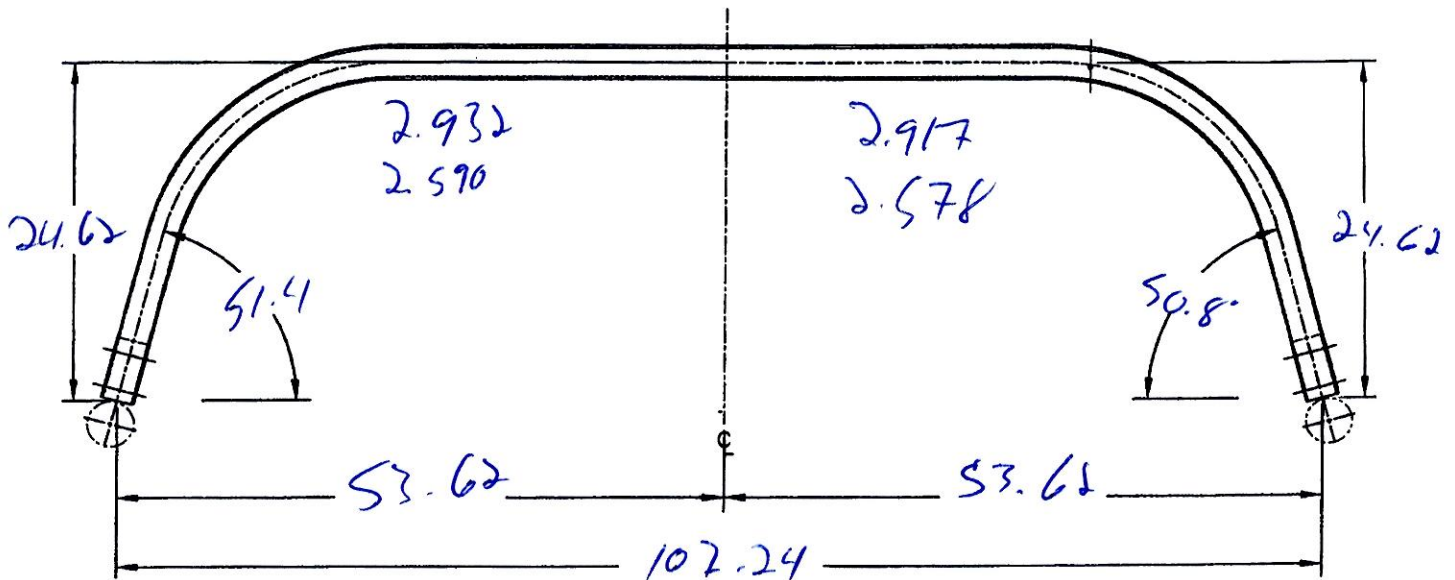
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m134257

50

DART AEROSPACE LTD		Work Order:	142086
Description: Crosstube High Aft (412)		Part Number:	D412-664-403
Inspection Dwg: D412-664-443 Rev: A		Page 1 of 1	

Required Dimension	Min	Max
Height	24.12	24.62
1/2 Span	53.56	53.82
Angle	49°	52°
Total Span	107.12	107.64
Bending Passes	8	--
Crushing	--	7%



	Side A	Side B
Bending Passes	7	4
Crushing	6.1%	6.1%
Comments		

QC15 Inspection	DAS
Date	49 16/03/29
	9-89

Rev	Date	Change	Revised by	Approved
A	14.07.08	New Issue	KJ	UP

Item	Qty	Part Number	Description
	-443		
1	X	D412-664-443	CROSSTUBE ASSEMBLY (412 HI AFT)
2	1	D6020-132	CROSSTUBE MATERIAL (132" MIN. LENGTH)
3	2	D3595-063-530	RUBBER CUSHION
4	1	D4909-1	SUPPORT
5	2	D4910-1	CHAFING SHIELD
7	4	MS21920-26	CLAMP
8	2	MS21920-28	CLAMP
9	A/R	SCOTCH-WELD DP460	EPOXY ADHESIVE, 3M SCOTCH-WELD
10	A/R	PROSEAL 890	SEALANT

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6020-132
FINISHED LENGTH = 130.10±0.060 (BEFORE BENDING/TRIMMING)
 - 2) FINISH: PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
MASK UNDERSIDE OF CROSSTUBE AS SHOWN (ZN C6-2, HATCHED AREA)
PAINT OUTSIDE PER DART QSI 005 4.2
AFTER PAINTING, REMOVE MASKING AND APPLY MATTE CLEAR COAT PER DART QSI 005 4.2
 - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
 - 6) IDENTIFICATION: SCRIBE DART P/N "D412-664-443" AND B/N ON INSIDE OF CUFF PER DART QSI 044 6.4 (VIBRATING STYLUS)
 - 7) WEIGHT: 90.2 lb AFTER MACHINING
88.7 lb FINISHED WEIGHT
 - 8) PART IS SYMMETRIC ABOUT CENTERLINE.
 - 9) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- BENDING**
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 7% (BASED ON O.D.) IN LOWER HALF OF R35 BEND AND 6% (BASED ON O.D.) ON REMAINING TUBE.
 - 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038. TO BE PERFORMED AFTER FINAL POST-BEND GRINDING. ANY ADDITIONAL GRINDING REQUIRES ANOTHER LPI INSPECTION.

ASSEMBLY

- 12) INSTALL D4909-1 CENTER SUPPORT USING A 0.04" TO 0.07" THICK LAYER OF SCOTCH-WELD DP460 PER QSI 015.
- 13) INSTALL MS21920-28 CLAMPS WITH D3595-063-530 RUBBER CUSHIONS TO SECURE THE D4909-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE ON TOP OF CROSSTUBE SUPPORT.
- 14) IF NOT ALREADY PRESENT ON CHAFING SHIELD, APPLY A THIN COAT OF PROSEAL 890 ON INSIDE CONCAVE SURFACE OF D4910-1 CHAFING SHIELD AND LET CURE PER MANUFACTURER'S INSTRUCTIONS. INSTALL PROSEALED D4910-1 CHAFING SHIELD ONTO CROSSTUBE BY APPLYING A THIN COAT OF PROSEAL 890 ONTO CROSSTUBE. BE SURE TO ELIMINATE ANY AIR GAPS.
- 15) TORQUE CLAMPS ON D4909-1 SUPPORT 80 TO 100 IN-LB. TORQUE CLAMPS ON D4910-1 CHAFING SHIELD 40 TO 50 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER ADHESIVES HAVE CURED FOR 24 HOURS.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 142086 MJS
10-02-24

UNDER REVIEW

07/15/14
LRF 15-561

UNDER REVIEW

07/17/14
LRF 14-661

RELEASED
2014-05-26

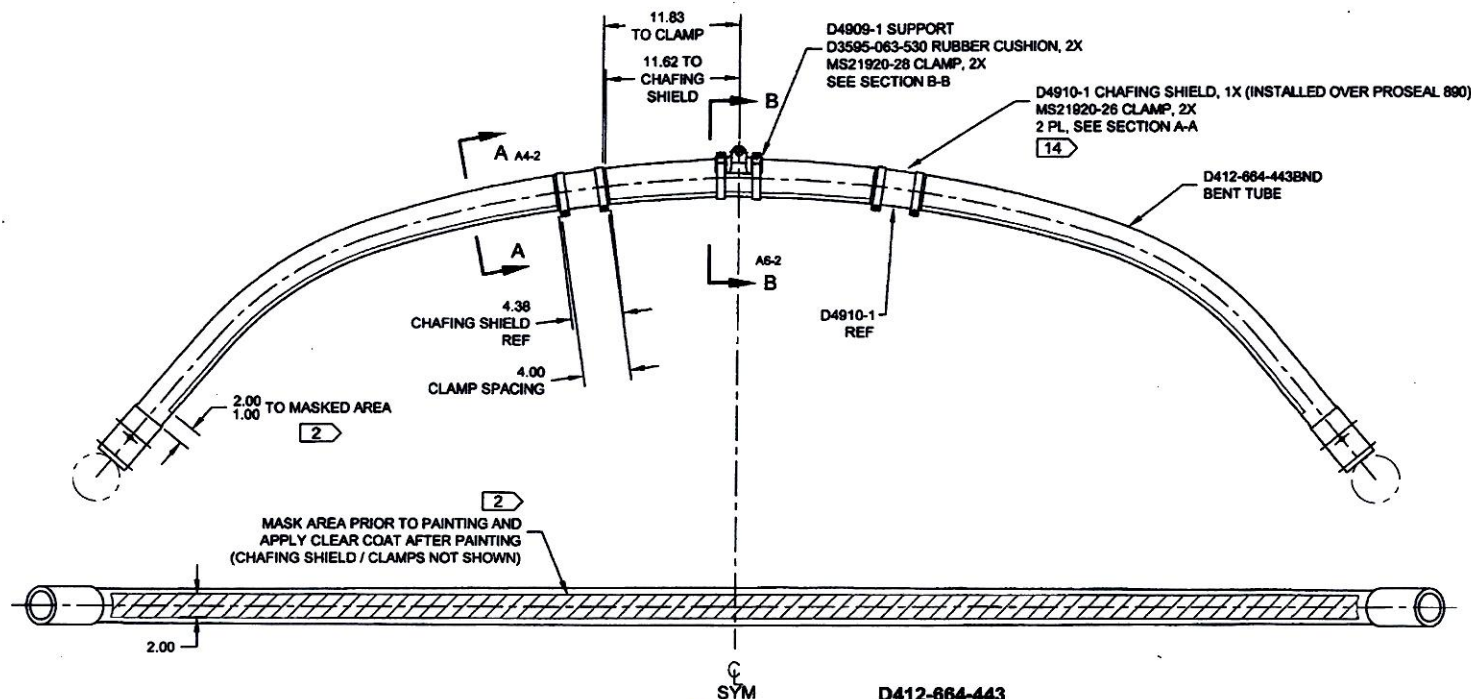
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REV.	DESCRIPTION	BY	DATE
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DE APPR.			
DATE	14.04.01		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. A
D412-664-443 SHEET 1 OF 4

TITLE SCALE
CROSSTUBE ASSY (412 HI AFT) NTS

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D412-664-443
ASSEMBLY DETAIL

APPLY 3M SCOTCH-WEELD DP460
BETWEEN D4909-1 SUPPORT AND
THE CROSSTUBE

D4909-1
SUPPORT
REF

D3595-063-530
RUBBER CUSHION
UNDER CLAMP, REF

SECTION B-B D4-2
SCALE 4X

MS21920-28
CLAMP, REF

SECTION A-A C6-2
SCALE 4X

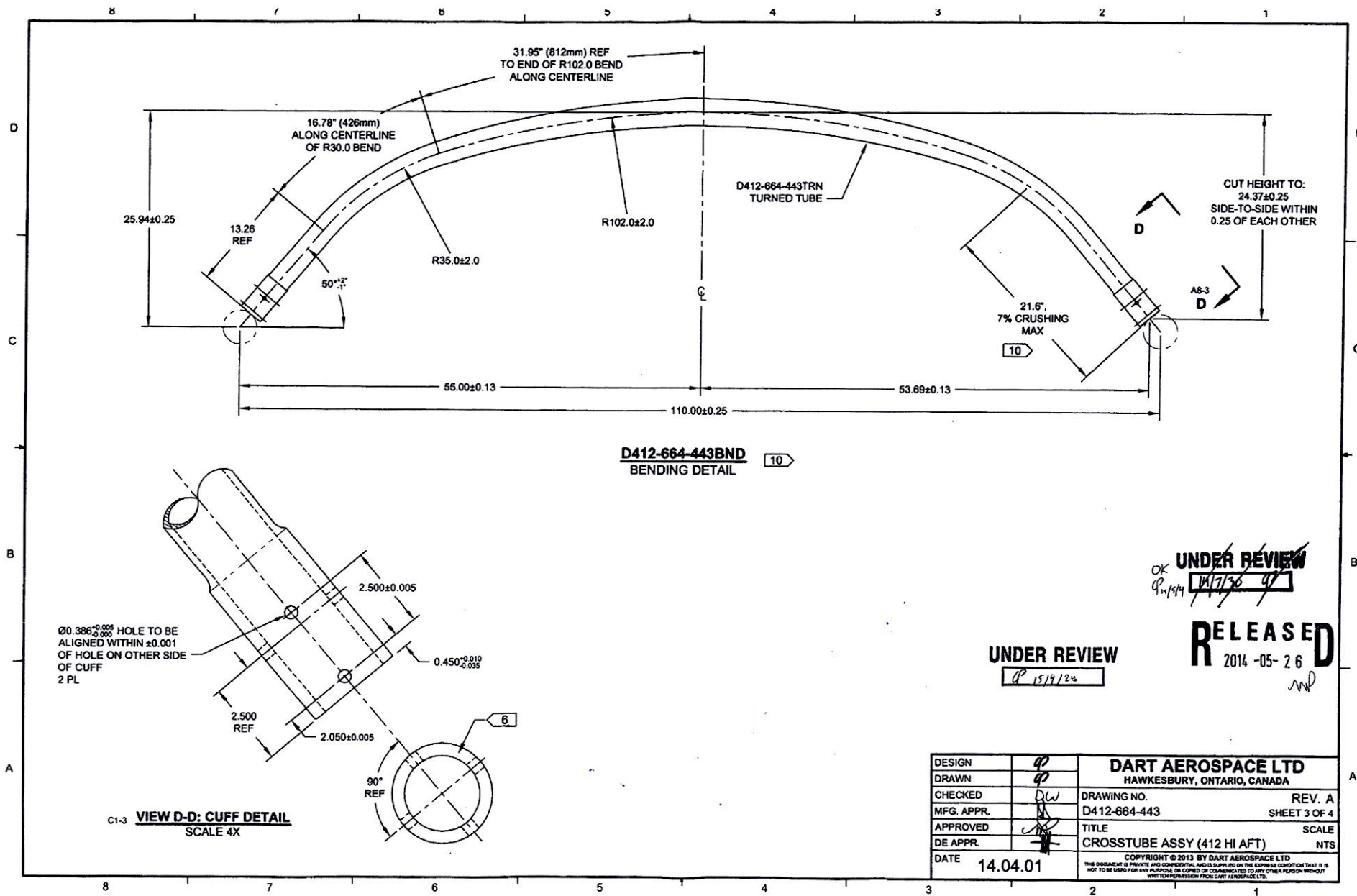
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REF

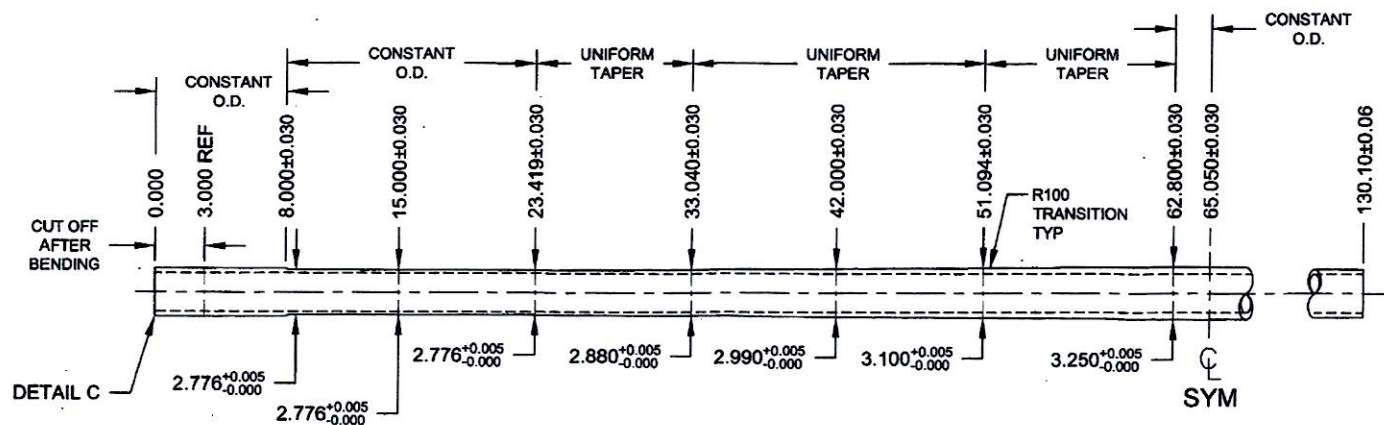
UNDER REVIEW
15/14/28

UNDER REVIEW
15/14/28

RELEASED
2014-05-26
WPD

DESIGN	<i>Q</i>	DART AEROSPACE LTD	
DRAWN	<i>Q</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>DeV</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>W</i>	D412-664-443	SHEET 2 OF 4
APPROVED	<i>W</i>	TITLE	SCALE
DE APPR.	<i>W</i>	CROSSTUBE ASSY (412 HI AFT)	NTS
DATE	14.04.01	COPYRIGHT © 2013 BY DART AEROSPACE LTD	
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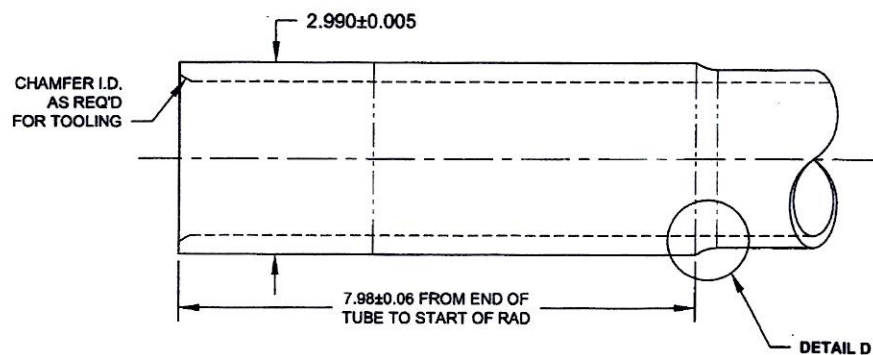




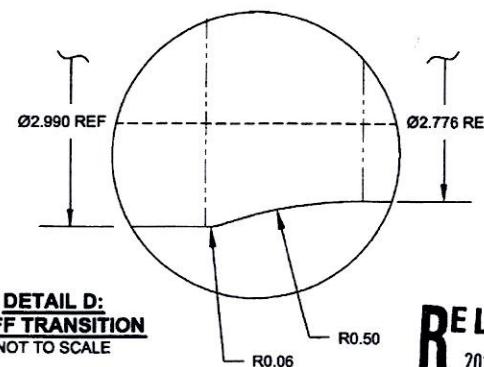
D412-664-443TRN
TURNING DETAIL

UNDER REVIEW

UP 15/14/20



DETAIL C:
CUFF TRANSITION
SCALE 4X



OK P. 15/14/20
UNDER REVIEW

RELEASED
2014-05-26

DESIGN	DP	DART AEROSPACE LTD	
DRAWN	DP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DP	DRAWING NO.	REV. A
MFG. APPR.	DP	D412-664-443	SHEET 4 OF 4
APPROVED	DP	TITLE	SCALE
DE APPR.	DP	CROSSTUBE ASSEMBLY (412 HI AFT)	NTS
DATE	14.04.01	COPYRIGHT © 2013 BY DART AEROSPACE LTD	
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Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO31971**

Purchase Order Date 4/7/2016

PO Print Date 4/11/2016

Page Number 3 of 4

Order From :
SKYSERVICE
6120 MIDFIELD ROAD
MISSISSAUGA, ONTARIO L5P 1B1
CANADA

VC-SKY001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name
Vendor Phone 905-678-5636

Ship To Contact
Ship To Phone
Ship Via: Delivered
Ship Acct:

Buyer Chantal Lavoie
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency CAD
FOB FCA - (Free Carrier)

					Line Total:	\$135.00
6	142086	D412-664-403 CROSSTUBE	4/11/2016 Yes 4/11/2016	1.00	\$135.00	\$135.00
					Line Total:	\$135.00
7	142087	D412-664-403 CROSSTUBE	4/11/2016 Yes 4/11/2016	1.00	\$135.00	\$135.00
LIQUID PENETRANT INSPECTION AS PER QSI 038 OR LPI AS PER ASTM 1417 LEVEL 2						
					Line Total:	\$135.00
8	143893	D412-664-403 CROSSTUBE	4/11/2016 Yes 4/11/2016	1.00	\$135.00	\$135.00

Note:

4/11/2016

**skyservice****Work Order Traveler**

Sky Service F.B.O. Inc.

DOT APP 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO27855	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: PO31971
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN:	CSN:	TSO:	
Task: UNSCHEDULED			Sequence: 1

Work Required:

CARRY OUT NDT (LIQUID PENETRANT CRACK TEST) ON THE FOLLOWING seven (7) CROSSTUBES:

ID# D412-664-403 STAINLESS STEEL AFT CROSSTUBES-HIGH

1 WORK ORDER ID 142085 2-WORK ORDER ID 142086
3.WORK ORDER ID 142087 4-WORK ORDER ID 143893

8016-01-17

ID# D412-664-203 AFT CROSSTUBES-HIGH

5 WORK ORDER ID 143853 6 WORK ORDER ID 143855
7 WORK ORDER ID 143856

Action Taken:						Date:	Initial/Stamp:
LIQUID PENETRANT INSPECTION CARRIED OUT ON ITEMS LISTED ABOVE (ITEMS 1-7) AS PER ASTM1417 M-13						<i>11 APR 20/6</i>	
NO APPARENT DEFECT FOUND							
PEN.(ZL-56, MPO13600), DEV.(SKD-S2, MPO11715), CLEANER(SKC-S, MPO13923)							
Description	Location	P/N	Qty	Batch	S/N Off	S/N On	

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature:	ACA/SCA Stamp 	Date:
Name: <i>CHRISTIAN BRIEN</i>		<i>11 APR 20/6</i>